

Date: Thursday, 3/23/2006 3:44:51 PM
 User: Kim Johnston

Process Sheet

SLIPT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR PROTECTOR AFT LH
Job Number	: 26355		
Estimate Number	: 11228		
P.O. Number	: N/A	Part Number	: D32813
This Issue	: 3/23/2006 S.O. No. : N/A	Drawing Number	: D3281 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 25122	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 4/10/2006
Checked & Approved By	: <u>06.03.24</u>	Qty:	20 Um: Each
Comment	: Est Rev: A 04.07.01 New issue: KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O 00000889 AFTDescription: Floor Protector BH

Possible Supplier: Delastek

Certificate of Conformity is required

2.0	D32813P	Floor Protector, Aft LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Floor Protector, BH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Date: Thursday, 3/23/2006 3:44:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR AFT LH

Job Number: 26355

Part Number: D32813

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Handwritten: DP 06/05/05 (1)

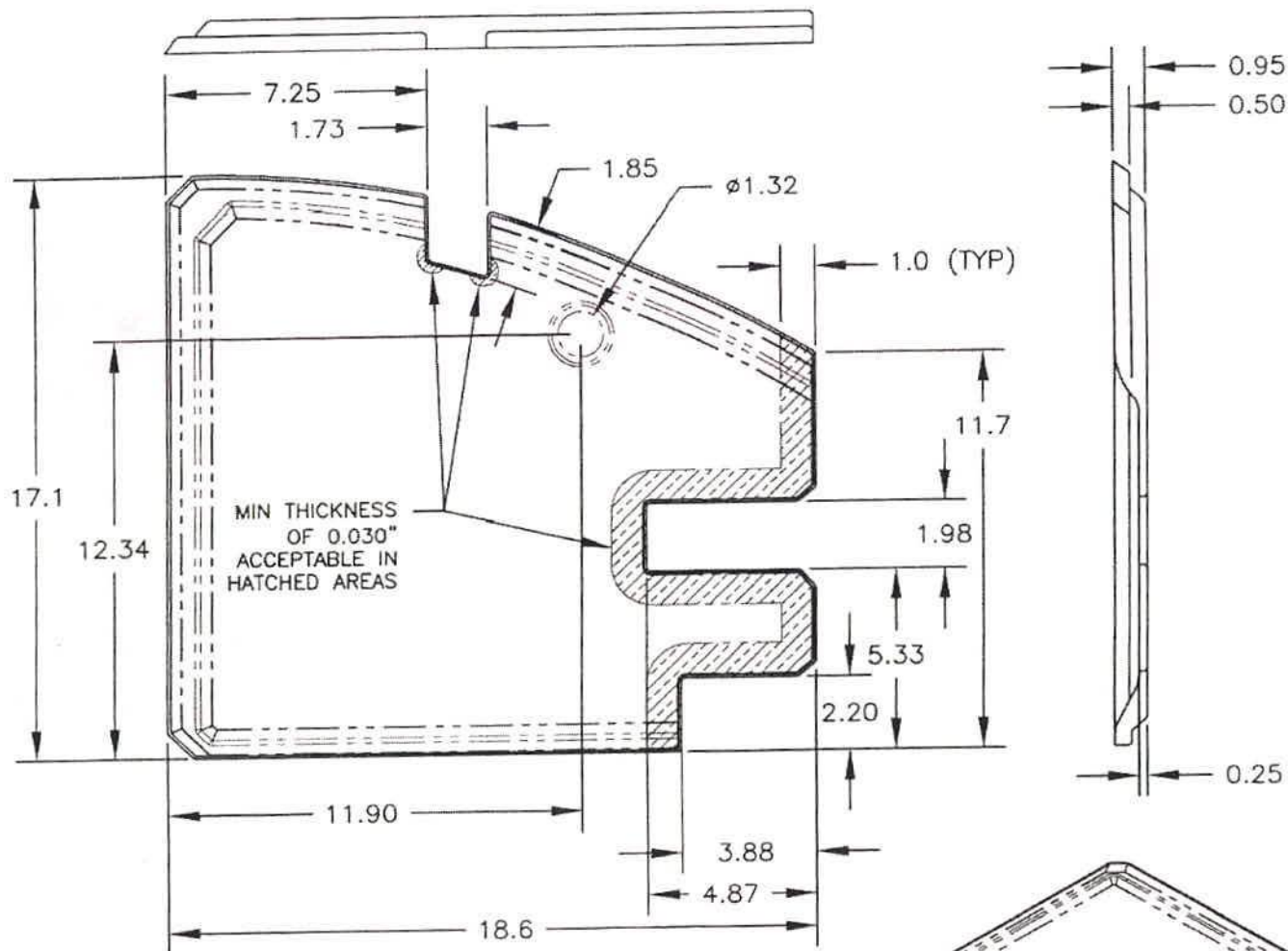
Job Completion



Handwritten: 06/05/05

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	HL	APPROVED	HL	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25				TITLE FLOOR PROTECTOR	SCALE 1:5
A	04.05.03		NEW ISSUE		
B	05.11.25		NOW LEXAN; DIMS AS MANUFACTURED		

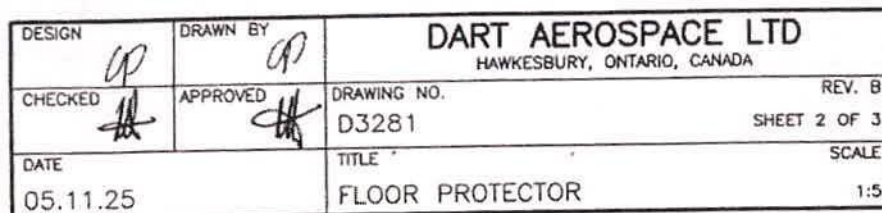
**RELEASED**
05.12.01**D3281-1 FLOOR PROTECTOR, FWD LH**

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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NO. 26355

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- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

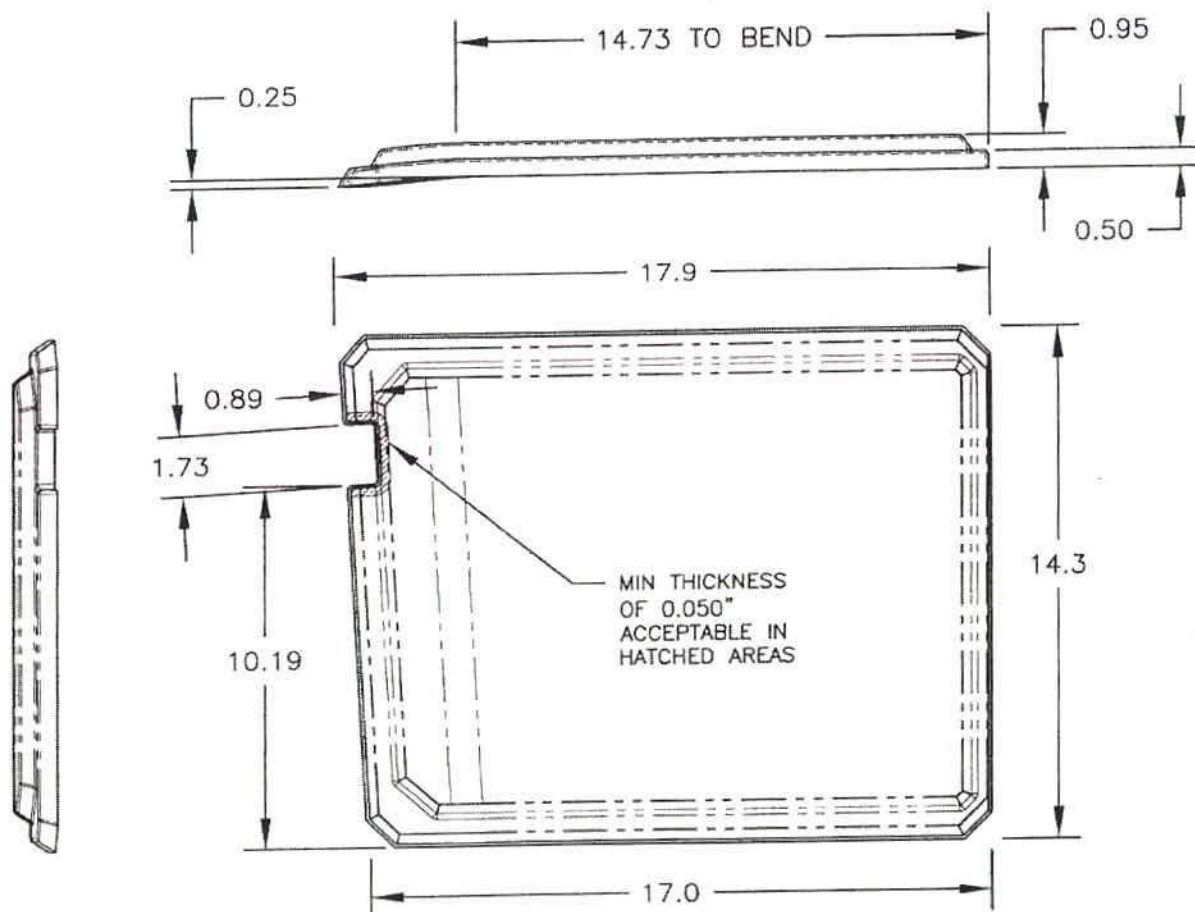
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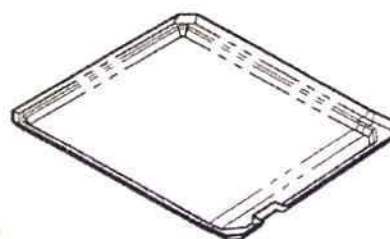
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DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>H</i>	APPROVED	<i>H</i>	DRAWING NO. D3281
DATE	05.11.25	TITLE	FLOOR PROTECTOR	REV. B SHEET 3 OF 3 SCALE 1:5



RELEASED
05.2.01. *[Signature]*



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ENGINEERING

D3281-3 FLOOR PROTECTOR. AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR. AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	10421
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Point de départ		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
12/05/06	28/03/06	4521	Linda Lacelle		PO00000889		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
20	0	1	DKC134-0046	D32813P Floor Protect Part 3 N° D3281-3 B/N: 26355 Selon dessin D3181 Rev.: B B/N: 26355 JOB: 35134 QTE: 1 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:



Quality department AQ-357

Date: Lundi, 2006-05-08 15:46:47
Utilisateur: Marc Dubé

Feuille de Procédé

Client	: DART	Dart Aerospace Ltd.	Nom Dessin	: FLOOR PROTECTOR AFT, LH	
Numéro Job	: 35134		Numéro Article	: DKC134-0046	
Numéro Soumission	: 2385		Numéro Dessin	: D3281	
Numéro B.A.	:		Projet Numéro	: DKC134	
Cette fois	: 2006-05-08	No. B.V. :	Révision dessin	: B	
Prsht Rev.	: NC		Matériel	: F6006	
Prem. fois	: - -	Type :	Date Dûe	: 2006-05-15	Qté: 1 UdM: UNITE
Job précédente	: 34785				
Écrit par	:				
Vérifié & Approuvé par	:				
Commentaires	:	N° de pièce: D3281-3			



Process Sheet Rév.: 01 Inverser le rang de la séquence
d'inspection et d'identification

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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1.0	APL0016	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
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Commentair Qty.: 0.167 UNITE(s)/Unit Total : 0.167 UNITE(s)
Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

N° de Lot: _____

2.0	SÉCHAGE/ ANEAL	SÉCHAGE / ANEALING
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Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.0333Hrs
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.
Inscrire sur la charte de température le numéro de Job du matériel au séchage.
de cuisson: _____

3.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 3.0000Hrs
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 1 Date: 9-5-06 Sceau: AB

Quantité: _____ Date: _____ Sceau: _____

Date: Lundi, 2006-05-08 15:46:47
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 35134

Nom Dessin: FLOOR PROTECTOR AFT, LH
Numéro Article: DKC134-0046

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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4.0	THERMOFORMAGE2	THERMOFORMAGE DES PIÈCE DART
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Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3281-3 à l'aide du moule N° D3281-3T1 sur le
thermoformeur 4' x 8'.

F.O: 9 mai 06

Autocontrôle du lot de pièce thermoformées.

Quantité: 1 Date: 5-5-06 Sceau: EP

Quantité: _____ Date: _____ Sceau: _____

5.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-3 à l'aide du gabarit de trimage N° D3281-3T2.

F.O: 10 mai 06

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 1 Date: 10-05-06 Sceau: 10

Quantité: _____ Date: _____ Sceau: _____

6.0	IDENTIFICATION4	IDENTIFICATION PIÈCES DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

N° de pièce: D3281-3

N° de Job: _____

Date de fabrication: _____

Sceau d'inspection.

Quantité: 1 Date: 11-05-06 Sceau: 72

Quantité: _____ Date: _____ Sceau: _____

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 35134

Nom Dessin: FLOOR PROTECTOR AFT, LH
Numéro Article: DKC134-0046

Numéro Job:



Séq.: Machine ou Opération: Description :

7.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 1 Date: 11 mai 06 Sceau:

8.0 EMBALLAGE EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton
identifiée comme suit:

N° de pièce: D3281-3
Date de fabrication: _____
N° de job: _____

Quantité: 1 Date: 11 mai 06 Sceau:

Quantité: _____ Date: _____ Sceau: _____